

Work Order ID 147878

Friday, June 17, 2016 8:24:33 AM

147878

Page 1

Item ID: D3407-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Tow Ring
Start Date: 6/21/2016 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 7/4/2016 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: MCS Date: JUN 17 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3407	Rev E								
100	Large Fab	0.00							
100									
Large Fab	Memo	0.30							
Large Fab	Weld D3407-1/-5 using welding rod TIG174 as per Dwg D3407 & QSI 004 A/R TIG174 ROD Batch: <u>M102576</u>								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
110									
QC	Memo	0.03							
Quality Control									
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.03							
Quality Control									

10 16-7-26

(10) 16-07-27 DAS 9 9-89

(10) 16-07-27 DAS 9 9-89

Work Order ID 147878

Friday, June 17, 2016 8:24:33 AM

147878

Page 2

Item ID: D3407-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Tow Ring
Start Date: 6/21/2016 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 7/4/2016 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per OSI005 4.3-Steel <i>M134798</i> Memo **Mask Threaded Section** START TIME: <i>7:05</i> OVEN TEMPERATURE: <i>400°</i> FINISH TIME: <i>7:35</i>	0.00 0.07				<i>10</i>	<i>0</i>	<i>16-08-18</i>	<i>23</i> <i>23</i>
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.03				<i>(10)</i>			DAS 38 9-89 AUG 18 2016
150 *150* Packaging Packaging	Identify as per dwg & Stock Location <i>ETS30</i> Memo	0.00 0.17			DAS 6 9-89	<i>10</i>	<i>Pc</i>		AUG 18 2016

Work Order ID 147878

Friday, June 17, 2016 8:24:34 AM

147878

Page 3

Item ID: D3407-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Tow Ring
Start Date: 6/21/2016 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 7/4/2016 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00					DAS 21 9-89		
160								AUG 18 2016	
QC	Memo	0.02							
Quality Control								DAS 21 9-89	AUG 18 2016

Picklist Print

Friday, June 17, 2016 8:24:38 AM

Page 1

Work Order ID: 147878

147878

Parent Item: D3407-041

D3407-041

Parent Item Name: Tow Ring

Start Date: 6/21/2016

Required Date: 7/4/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A05.10.14New issueKJ/EC
IPP Rev:B 08-09-09 revE as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3407-1		Manufactured	No			100	Each	0.0000	1	10			
D3407-1									**			<u>EL 16-7-26</u>	
Stem													
D3407-5		Manufactured	No			100	Each	3.0000	1	10			
D3407-5									**			<u>EL 16-7-26</u>	
Ring													

Location

Loc Qty

Loc Code

WA001

3

145891

3

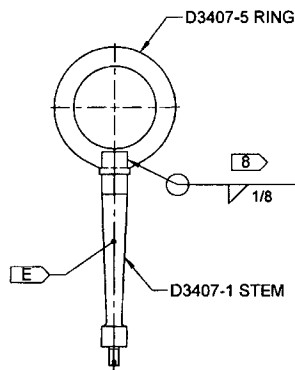
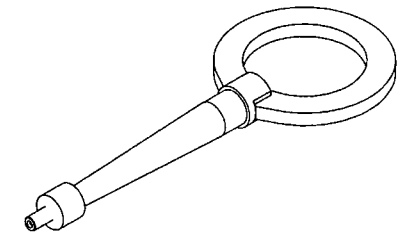
145892 x 4

147949 x 3

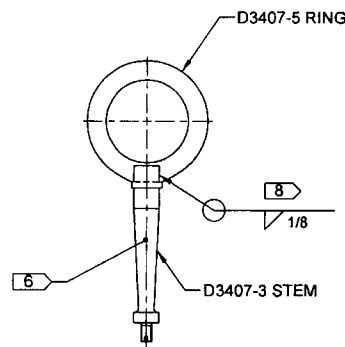
3

QTY -041	QTY -043	QTY -045	PART NUMBER	DESCRIPTION
X			D3407-041	TOW RING
	X		D3407-043	TOW RING
		X	D3407-045	TOW RING
1			D3407-1	STEM
	1		D3407-3	STEM
1	1	1	D3407-5	RING
		1	D3407-7	STEM

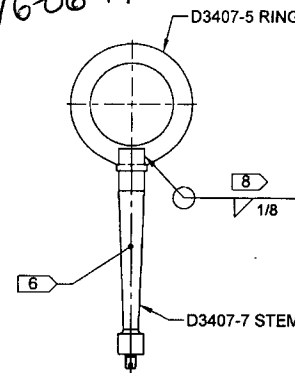
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 147878 MW
1606-17



D3407-041 TOW RING



D3407-043 TOW RING

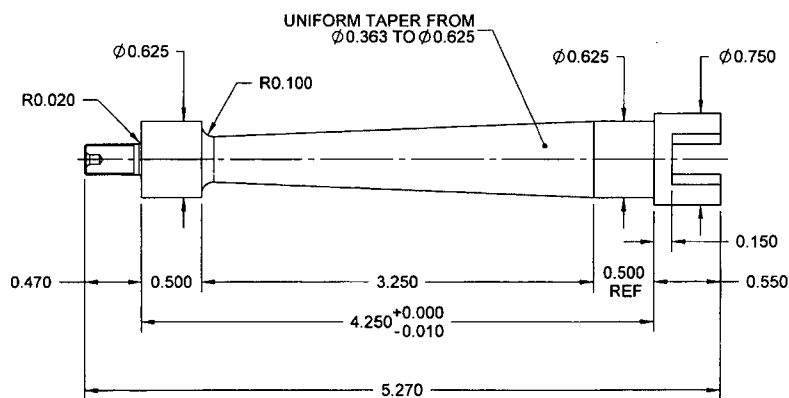
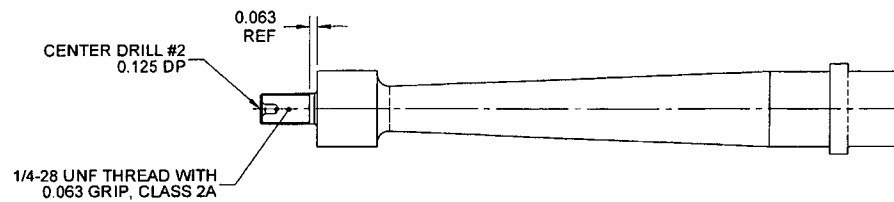


D3407-045 TOW RING

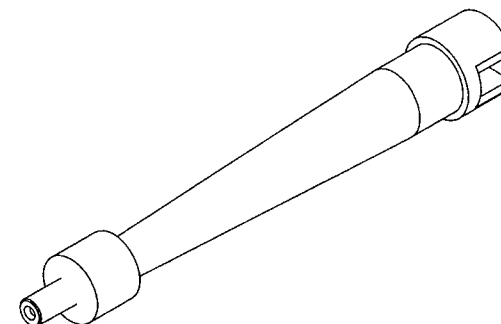
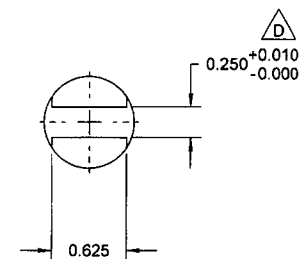
RELEASED
07-08-01-11

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
 - 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

REV.	DESCRIPTION	BY	DATE
E	ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 6 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY	PH	08.07.23
D	D3407-1/3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/3 (ZN B6-4); REASON: PRODUCTION FACILITY	PH	08.04.07
C	-1/3 LONGER FOR FIT W/WASHER	CP	05.09.09
B	UPDATE DIAMETER, THREAD CLASS ADDED	CP	05.06.17
A	NEW ISSUE	CP	05.03.16
DESIGN	DRAWN	CHECKED	MFG. APPR.
DATE	08.07.23		
DART AEROSPACE USA, INC. PORT HADLOCK, WA DRAWING NO. D3407 TITLE TOW RING REV. E SHEET 1 OF 5 SCALE NTS COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			



D3407-1 STEM

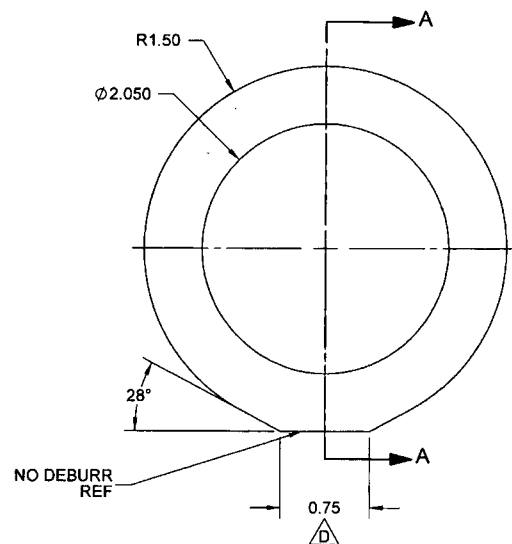


RELEASED

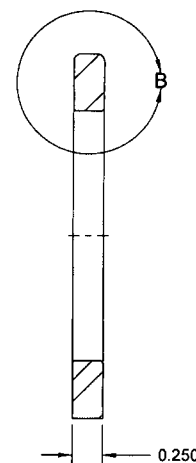
NOTES:

- 1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs

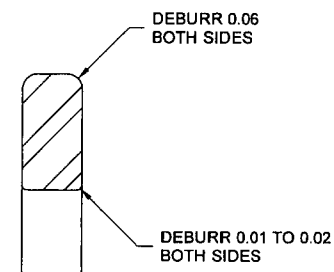
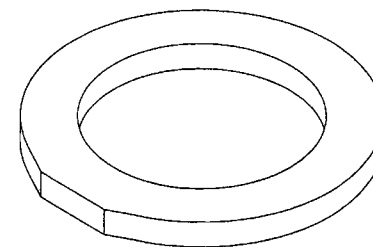
DESIGN		DART AEROSPACE USA, INC.	
DRAWN	<i>JP</i>	PORT HADLOCK, WA	
CHECKED	<i>JP</i>	DRAWING NO.	REV.
MFG. APPR.	<i>JP</i>	D3407	SHEET 2 OF 5
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	TOW RING	NT
DATE	08.07.23	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC.	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMPILED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			



D3407-5 RING



SECTION A-A



**DETAIL B
SCALE 2X**

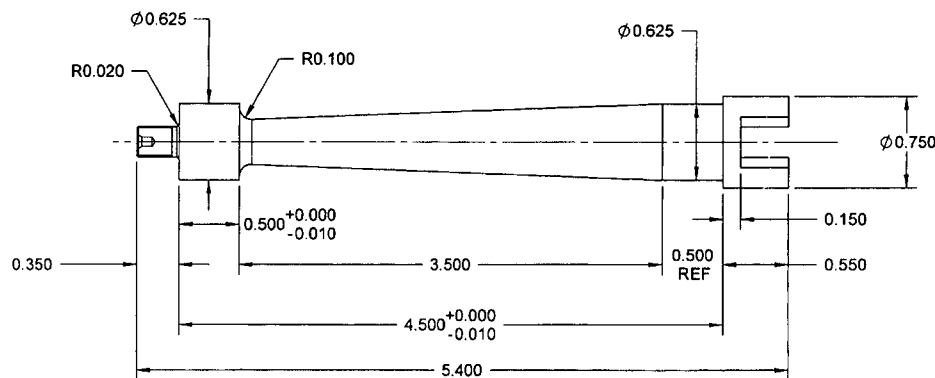
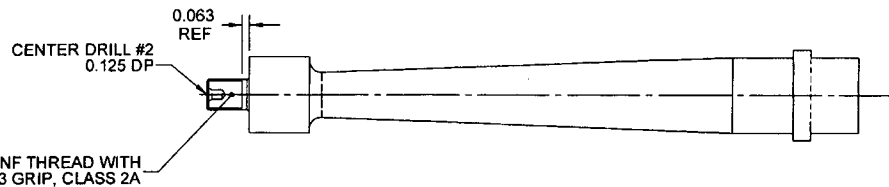
RELEASED
08-08-01/11/11

NOTES:

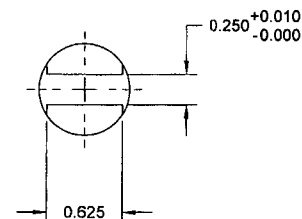
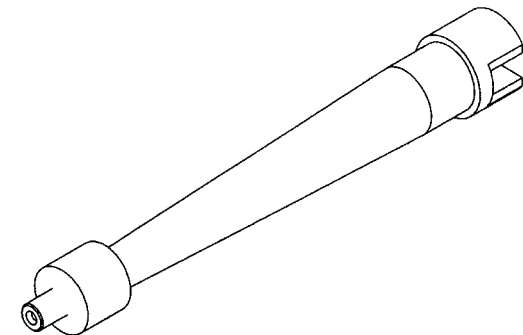
- 1) MATERIAL: 17-4 PH SS BAR PER AMS 5604/5643 (REF. DART SPEC M17-4-B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.27 lbs

DESIGN	90	DART AEROSPACE USA, INC.	
DRAWN	1/15	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3407	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		TOW RING	NTS
DATE	08.07.23	COPYRIGHT © 2006 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRINTED AND CONTAINS NO CHANGES. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1



D3407-7 STEM



RELEASED

- NOTES:
1) MATERIAL: 17-4 PH SS ROUND BAR PER AMS 5643 (REF. DART SPEC M17-4-R)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS
6) IDENTIFICATION: N/A
7) WEIGHT: 0.34 lbs

DESIGN	AJS	DART AEROSPACE USA, INC.	
DRAWN	<i>[Signature]</i>	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3407	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TOW RING	NTS
DATE	08.07.23	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1